

# Work Order ID 77491

**\*77491\***

December-08-11 1:41:17 PM

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Item ID: D6201 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: "T" Extrusion  
 Start Date: 08/12/2011 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 22/12/2011 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 11/12/08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6201	Rev A

100 PURCHASING 0.00  
**\*100\***  
 Purchasing  
 Purchasing  
 Memo  
 Issue P/O: 15711 a)Description: T-beam extrusionb) 4.00" x 4.00" x 0.375" c) Minimum Ultimate Tensile Strength = 38ksid) Minimum Yield Tensile strength = 35ksi e) Material: 6061-T6/T6511 (QQ-A-200/8)  
 f)Material certification required

CX 11/12/20 12

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
**\*110\***  
 Packaging  
 Packaging  
 Memo  
 Ensure material certification is attached

Pull 11/23 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 77491****\*77491\***

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Item ID: D6201      Accept      **\*N900040100\***      Setup      Start      **\*NS1\***  
Revision ID:      Stop      **\*NS2\***  
Item Name: "T" Extrusion  
Start Date: 08/12/2011      Start Qty: 12.00      **\*12\***      Cust Item ID:  
Required Date: 22/12/2011      Req'd Qty: 12.00      **\*12\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start      **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop      **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6104								
130	Identify as per dwg & Stock Location: <u>28</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

11/14/2011  
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

December-08-11 1:41:22 PM

Work Order ID: 77491

\*77491\*

Parent Item: D6201

\*D6201\*

Parent Item Name: "T" Extrusion

Start Date: 08/12/2011

Required Date: 22/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A: 01.05.15New Issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6201P		Purchased	No			110	f	0.0000	1	12			
*D6201P*									**				
T Extrusion 4X4X3/8													

11/12/22 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



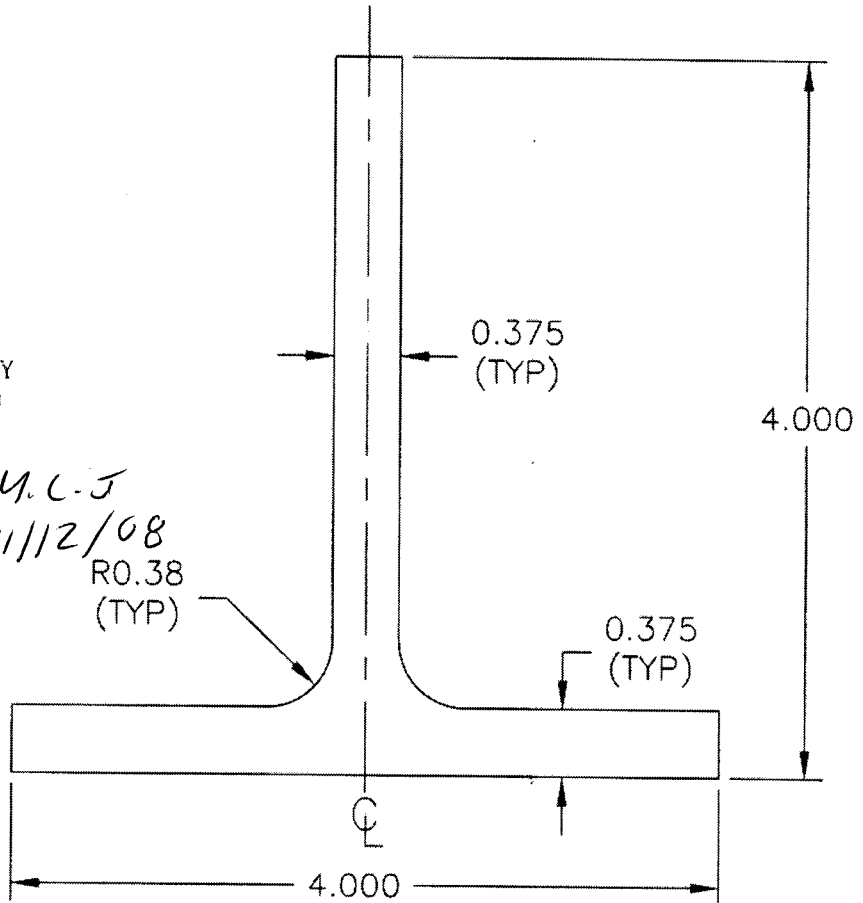
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 *[Signature]*

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *77491 M.C.J.*

*11/12/08*  
R0.38  
(TYP)



D6201-XXX T-BEAM EXTRUSION  
WHERE XXX IS LENGTH IN INCHES

EG.  
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET  
4.000" x 4.000" x 0.375"  
6061-T6/T6511 (QQ-A-200/8)  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO15711

Purchase Order Date 12/20/11

PO Print Date 12/20/11

Page Number 2 of 2

Order From :

VC-CAM002

CAMPI STEEL  
935 BOUL. DU HAVRE  
VALLEYFIELD, QC J6S 5L1  
CA

Contact Name

Vendor Phone 800 667 4248

Vendor Fax 450 377 5696

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

D6201P

T Extrusion 4X4X3/8

12/23/11

Yes

12.00

f

Yours ppd

\$18.7500

\$225.00

Special Inst:

AS PER DWG D6201 REV. A

B77491

T-BEAM EXTRUSION SIZE 4" X 4" X

.375"

MATERIAL: 6061-T6 / T6511 AS PER QQ-

A-200/8

MINIMUM YIELD TENSILE STRENGTH

= 35 KSI

MINIMUM ULTIMATE TENSILE

STRENGTH = 38 KSI

PO Total:

\$416.91



Change Nbr: 1

Change Date: 12/20/11

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



935, boul. du Havre  
Valleyfield (Québec)  
J6S 5L1

TÉLÉPHONE : 450 377-4248  
FAX : 450 377-5696

MONTREAL : 514 336-4248  
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS  
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248  
FAX : 1 866 456-4242

On a du Savoir "FER"

VENDU À / SOLD TO:

613-632-5200

613-632-1053

EXPÉDIEZ À / SHIP TO:

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY,  
ONTARIO  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY,  
ONTARIO  
K6A 1K7

COMMANDE  
ORDER

N° 192189

DATE

20/12/11

BON DE LIVRAISON  
PACKING SLIP

N°

DATE DE LIVRAISON  
DELIVERY DATE

22/12/11

VOTRE N° DE COMMANDE / YOUR P.O. N°	VEND. / SALESM.	CODE CLIENT / CUST. CODE	EXPÉDIE PAR / SHIP VIA	TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
15711	SD	DAER		NET 30 JOURS	2R		001

CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DESCRIPTION	POIDS WEIGHT	PROX. PRICE	PAR PER *	MONTANT AMOUNT
	1		ALU. T-BAR 6061T6 4 X 4 X 3/8 1 X 12'	1.00			
			LETRE DE CONFORMIT				

\* Unités de mesure: Cent livres • CPI Centpieds • UN Unité • PI Pied • PC Pied carré  
Units of measure: Hundred pounds • CPI Hundred feet • UN Unit • PI Foot • PC Square foot

POIDS TOTAL  
TOTAL WEIGHT

1

CONDITIONS:

LES MATÉRIAUX LIVRÉS ET FACTURÉS SONT À LA CHARGE DE L'ACHETEUR. • LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE CELLE DU FABRICANT. • L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES: NET 30 JOURS DE LA DATE DE FACTURATION, ET TOUT COMPTE EN DÉFAUT DANS LES 30 JOURS ENVIRONNANT LE PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU Vendeur, À SON CHOIX, DE RÉCLAMER LE DIT SOLDE OU PROX. DE VENTE OU DE REPOSSESSION. • TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES CINQ JOURS SUR PRÉSENTATION DE CE DOCUMENT. • TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE RETOURNÉE. • AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. • TOUTE MARCHANDISE RETOURNÉE EST SOUVERAINEMENT À DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS:

ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACIER CAMP INC." UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED. ALL LOST MATERIALS ARE AT THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE BUYER HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF 2% PER MONTH OR 25% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH THIS CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE REPOSSESSION OF THE GOODS SOLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE THAT HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

MARCHANDISE REÇUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION

X

A/Y M/M J/D

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL  
SUB TOTAL

T.P.S.  
G.S.T.

T.V.Q. / T.V.H.  
Q.S.T. / H.S.T.

TOTAL

PRÉPARÉ / PREPARED

VÉRIFIÉ / VERIFIED

LIVRÉ / DELIVERED

HEURE / TIME

PAR  
BY

PAR  
BY

PAR  
BY

N° ENR. TPS / GST REG. N° R 135 634 717 • N° ENR. TVQ / QST REG. N° 1 015 668 543

**KAISER ALUMINUM  
MATERIAL CERTIFICATION**

PAGE 1

<u>PQ H7S-1 N22214</u>		<u>09/09/09</u>
<u>SOLD TO</u>	<u>PURCHASE ORDER</u>	<u>DATE PRINTED</u>
<u>V872002</u>	<u>TER 4.000X4.000X.375</u>	
<u>CUSTOMER PART NUMBER</u>	<u>DESCRIPTION</u>	
<u>734563-003</u>	<u>C9428 142</u>	<u>6061-T6</u>
<u>RELEASE-ITEM</u>	<u>LOT</u>	<u>ALLOY/TEMPER</u>

**MECHANICAL PROPERTY RESULTS**

REFERENCE	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
C9428 142	0001 1	50.1	44.3	14.8	RE 97	N/A	N/A

**CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER**

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	Ea Tot
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA	0.05-0.15

S 4/12/28

**Applicable Requirements:**

ASTM-B308-02-STENCILED  
EXCEPT HARDNESS TESTED PER  
C=0, 1.5 AQL SAMPLING PLAN  
ASTM-B221-08, AMS-QQ-A-200/8  
AMS-QQ-A-200/16 UNS#96061  
ASME-SB221 1998 SECT II

Kaiser Aluminum Canada Limited ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

Bill Brennan

**CERTIFICAT DE CONFORMITÉ  
LETTER OF COMPLIANCE**

Acier Campi INC.  
935 BOUL Du Havre  
Salaberry-De-Valleyfield Québec  
J6S-5L1  
Fax : (514) 336-4246

DATE: 28 DECEMBRE 2011  
BON DE COMMANDE: 50580  
FACTURE: H94502

**DESCRIPTION:**

1. 1.MCX 4 X 4 X 3/8 X 144

**Ceci certifie que le matériel mentionné en rubrique est conforme aux spécifications suivantes:  
This is to certify the above mentioned material complies to the following specifications:**

6061-T6, BARRE EN « T », ALUMINIUM

Kaiser Lot # C9428142

Bien à vous  
Respectfully,

  
Guillaume Alarie-Fraser